

Date: Monday, 18/08/2008 4:03:32 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CAP
Job Number	: 41340		
Estimate Number	: 10519		
P.O. Number	:	Part Number	: D2855
This Issue	: 18/08/2008 S.O. No. :	Drawing Number	: D2855 REV. A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 18/08/2008 Type : PURCHASED PARTS	Drawing Revision	: A
Previous Run	: 39562	Material	:
Written By	:	Due Date	: 15/09/2008 Qty: 25 Um: Each
Checked & Approved By	: <u>NO 08.8.18</u>		
Comment	: Est: B 00.06.22 Added receiving step & removed P/O for powder coat EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 6979C208108/19

Cast per Dwg D2855

Material Release Note Required

(25)

2.0	D2855P	Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 25.0000 Each(s)  
 CAP

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Recieve &amp; Inspect for Transit Damage

Ensure Material Release Note is attached

P 8/8/28 (25)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

S 08/08/28 (25) centered

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1- Drill as per Dwg D2855 using DT8235

2- Open holes to 19/64"

3- Deburr

E 08/09/10 (25)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 18/08/2008 4:03:33 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CAP

Job Number: 41340

Part Number: D2855

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/11 (25)

7.0

POWDER COATING

POWDER COATING



M108523



(25X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:30  
3200  
2:00

M-L 08/09/12

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FL 08/09/15 (25)

9.0

ALS71032225

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 50.0000 Each(s)

INSERT

Pick:

Qty Part Number Description Batch  
2 ALS7-1032-225 Insert  
or AKS7-1032-225  
or ALS4-1032-225  
or AKS4-1032-225

~~M105819~~  
M100489

FL

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Inserts as per Dwg D2855

FL 08/09/15

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/15 (25) counter

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-7

FL 08/09/15 (25)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

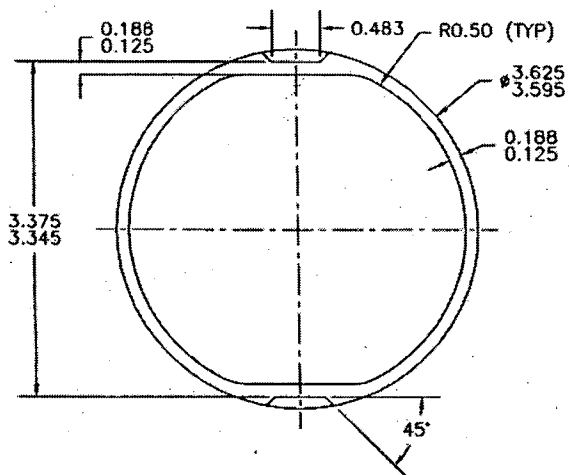
**NOTE:** Date & initial all entries



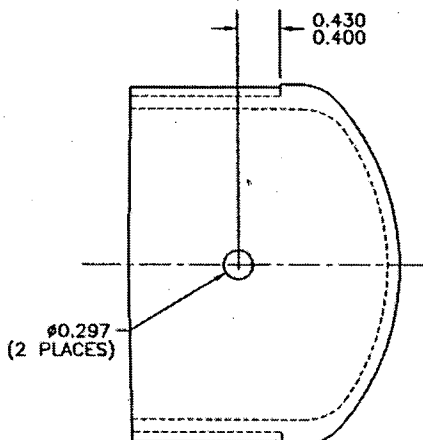
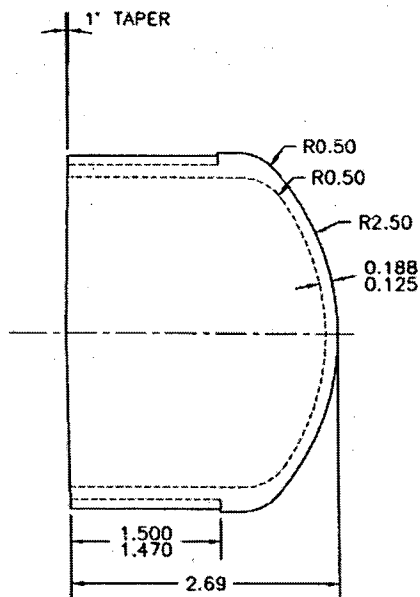
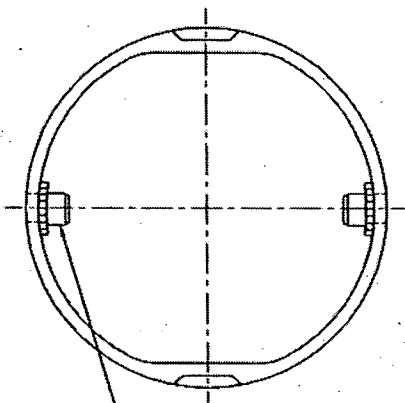
DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
DATE		D2855	SHEET 1 OF 1
98.12.12		TITLE	SCALE
A	96.12.12	CAP	NIS
NEW ISSUE (WAS D2575 REV. E)			

RELEASED  
98.12.14 DS

D2855 CASTING DETAIL



D2855 FINISHING DETAIL



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR  
ALS7-1032-225, OR AKS4-1032-225) INSERT ON  
INSIDE OF CAP (AFTER POWDER COAT)  
(2 PLACES)

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

MATERIAL: CAST ALUMINIUM ALLOY A356.2 (F)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 41310

7 CERTIFICAT DE CONFORMITÉ  
CERTIFICATE OF COMPLIANCE

FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE  
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD

714-716 CALAIS, DORVAL, QC H9P-2P3  
TEL : (514) 631-1331 FAX: (514) 631-8448

Expédié à  
Shipped

**DART AEROSPACE**

A.F. & P.W. Série no./Serial no.

**1270 Aberdeen Street**

Packing  
Date: **26/08/2008** Slip No. **32689**

**Hawksbury, ON, K6A 1K7**

Votre No. Commande **00006979**  
Your order No.

Ceci est pour certifié que le matériel liste ci-dessous est selon les spécifications du bon d'achat ci-haut, et que les documents en evidence des rapports et certificats de détaillante sont en filière dans notre bureau.

This is to certify that the material listed below is according to your specifications on above P.O. and that documentary evidence of the tests or release certificates from the original supplier are on file in this office.

Quantité Quantity	Description	Notre No. Our No.	Spécifications	Note d'autorisation Incoming Release note
25	D 2855 CAP	Z098046	A356.2 <i>Stocks</i>	Ingot#851118

Analyse  
Analysis (as in ingot)

(Si)	7.80%	(Al)	balance
(Fe)	0.06%		
(Cu)	0.00%		
(Mn)	0.00%		
(Mg)	0.42%		
(Zn)	<0.01%		
(Ti)	0.16%		

Donne  
Yield :

Résistance à la tension :  
Tensile Strength :

Allongement par pouce carré :  
P.S.I. Elongation :

%

Pour et au nom de  
For and on behalf of :

FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE  
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD

Dept/Dep :  
Par/Per :

Coc-100

# Aluminum Foundry Ltd

714-716 Calais  
Dorval, Québec H9P 2P3  
Tel: (514) 631-1331  
Fax: (514) 631-8448

## Packing Slip

Packing Slip No.: 32689  
Date: Aug 26, 2008  
Page: 1

<b>Sold to:</b>		<b>Ship to:</b>	
DART AEROSPACE 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7		DART AEROSPACE 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7	
<b>Order No.:</b> PO00006979		<b>Sold By:</b>	
<b>Shipped By:</b> FEDEX 157193240		<b>Ship Date:</b> Aug 26, 2008	
<b>Tracking No.:</b>			

Item No.	Unit	Description	Quantity
Z098046	Each	D2855 CAP REV.A  1 Copc  08/26/28	25
Comment:			